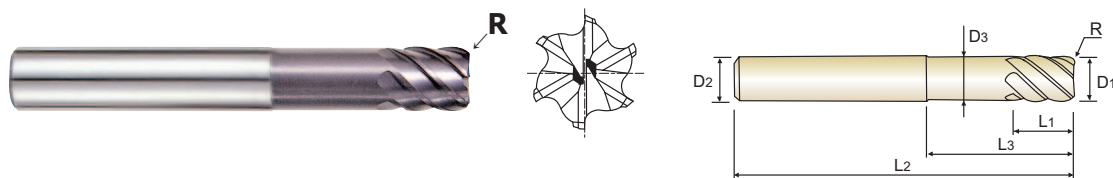


CARBIDE, 6 FLUTE 45° HELIX STUB LENGTH CORNER RADIUS VOLLHARTMETALL, 6 SCHNEIDEN 45° RECHTSSPIRALE EXTRA KURZ ECKENRADIUS

- ▶ High speed cutting
- ▶ Excellent performance in dry cutting
- ▶ Cutting up to the dimension three times as much as the diameter by reduced Neck

- ▶ Hochgeschwindigkeitsfräsen.
- ▶ Ausgezeichnete Leistung bei Trocken - Zerspanung.
- ▶ Fräst bis zur dreifachen Größe des Durchmessers des abgesetzten Schaftteils.



Unit : mm

EDP No.		Corner Radius	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter
PLAIN	FLAT	R	D1	D2	L1	L3	L2	D3
EM897060	EM898060	R0.5	6.0	6	6	14	50	5.7
EM897080	EM898080	R0.5	8.0	8	8	24	60	7.65
EM897100	EM898100	R1.0	10.0	10	10	30	70	9.65
EM897120	EM898120	R1.0	12.0	12	12	30	75	11.6

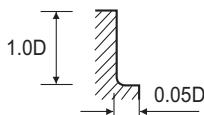
Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRC30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	◎	◎	○				○				

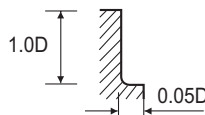
CARBIDE, 4 FLUTE STUB CORNER RADIUS - SIDE CUTTING
VOLLHARTMETALL, 4 SCHNEIDEN EXTRA KURZ ECKENRADIUS - SEITENFRÄSEN
EM839, EM849 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55		HRc55 ~ HRc65	
STRENGTH	~ 1000N/mm ²		1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²		2000N/mm ² ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2.0	13870	340	9070	205	6050	60		
2.5	12290	360	7870	220	5040	65		
3.0	10700	385	6670	240	4030	70	2280	70
3.5	9890	535	6100	330	3780	70	2030	70
4.0	9070	685	5540	420	3530	70	1780	70
5.0	7560	720	4540	430	2780	85	1510	70
6.0	6670	790	4030	490	2400	95	1320	70
8.0	5040	850	3020	455	2020	130	1010	70
10.0	3910	730	2400	360	1630	110	820	60
12.0	3290	625	2020	300	1390	95	670	60
16.0	2640	490	1630	240	1080	70	530	35


RPM = rev./min.
FEED = mm/min.

CARBIDE, 6 FLUTE STUB CORNER RADIUS - SIDE CUTTING
VOLLHARTMETALL, 6 SCHNEIDEN EXTRA KURZ ECKENRADIUS - SEITENFRÄSEN
EM897, EM898 SERIES

MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	~ HRc30		HRc30 ~ HRc45		HRc45 ~ HRc55		HRc55 ~ HRc65	
STRENGTH	~ 1000N/mm ²		1000 ~ 1500N/mm ²		1500 ~ 2000N/mm ²		2000N/mm ² ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	6670	790	4030	490	2400	95	1320	70
8.0	5040	850	3020	455	2020	130	1010	70
10.0	3910	730	2400	360	1630	110	820	60
12.0	3290	625	2020	300	1390	95	670	60


RPM = rev./min.
FEED = mm/min.